Work Orde June-12-13 9:15		2867	4	*10	2867*						Page 1	
Revision ID:	D3137-5		0° *24*	Accept	*N900	<b>040</b>	100	<b>)*</b> s	Setup Start Stop	171	S1*	
	Washer	, t	0						Stop	^ N.	S2*	
	6/11/13	Start &t.,1 7.19	*24*		Cust Item I	D:						
Required Date:	6/11/13	Req'd Qty: 24.00	*24*		Customer:							
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Approvals:	Process Pla	in: MLJ	Date: 13-06-14	Tooling:	Da	ate:		K	tun Start	I <b>V</b> I	R1*	
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			Stop	*N	R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
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110		QC2- Inspect parts off m	nachine FAI/FAIB	0.00	,			0.5				
*110* QC Quality Control		Memo		0.00	§ 13/ <b>%</b> /2	2_		50	- <b>- - - - -</b> -		•	
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Dowt N						Rework Scrap		l ,	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
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Work Ord  June-12-13 9:1		02867		*102	2867*						Page 2	_
Item ID: Revision ID: Item Name:	D3137-5 Washer			Accept	*N900	<b>040</b>	100	)* s	etup Star Sto	IV	S1* S2*	=
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Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*130 *130* HandFinish Hand Finishing		Chemical Conversion Co  Memo	at per QSI005 4.1	0.00				50			* 05 /3.0	06.24
140 *1 <b>4∩</b> *		QC3 Inspect Part Finish		0.00				_50	<b>x</b>		- 50	
QC Quality Control		Мето		0.00			·				13-6	1-25
160 *160* Packaging		Identify as per dwg & Sto	ock Location: 8723	0.00				50,	<b>\</b>			

Memo

Packaging

DQA:			_ Date:										™ A DT
						WORK ORDER NON	-C(	ONFO	RMANCE / UI				AEROSPACE
QA Closed:			Date:								Vork Order u	pdate only	
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	••••					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap		<u> </u>	Machining	Small Fab	Pro	od. Eng. Coor.	Quality
						Use-as-is		Therr	moforming	Finishing	Rec/Sto	re/Packaging	Other
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		Bending				Bend		Folio/F	Program		Outside Din	nensions	Pressure/Forced
~		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks			L	Broken/Damage/Defect	L	Hardwa	are	Ĺ	Part Incorre	ct	Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Un	nqualified	Part Lost/M	issing	Weld
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Work Orde June-12-13 9:15		02867		*102	2867*							Page 3
Revision ID: Item Name:	D3137-5 Washer 6/11/13	Start Qty: 24.00	*24*	Accept	*N900		100	)* s	Setup	Start Stop	ı VI -	S1* S2*
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Approvals:	Process	Plan:	Date:	Tooling:	Da	nte:		ŀ	Run	Start	171	R1*
	QC:		Date:	SPC (Y/N):	Da	ıte:				Stop	*N	R2*
Sequence ID/ Work Center II 170 *170*	)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	ject y <i>[3]</i>	Reject Number	Insp. Stamp
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QA CIOSCU.		- Dutc.					<u> </u>			`	· . <u></u>	
Work Orde	er:				DISPOSITION			AG	AINSI D	EPARTMENT,	/PROCESS	
					Rework			Skid-tube Cros	sstube	] ,	Water Jet	Engineering
Part N	۱o				Scrap			Machining Sma	all Fab		d. Eng. Coor.	Quality
					Use-as-is			~ <b>—</b>	nishing	Rec/Sto	re/Packaging	Other
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Root		1		Desc	ription of work order update		Initial	Action		Sign &		,
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									_			

## **Picklist Print**

June-12-13 9:15:44 AM

Work Order ID:

102867

Parent Item:

D3137-5

Parent Item Name:

Washer

**Start Date:** 6/11/13

Required Date: 6/11/13

**Start Qty: 24.00** 

Required Qty: 24.00

Comments:

IPP A04.11.04New issueKJ/JLM

IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No	A-1		100	f	80.7810	0.0208	0.5254728			
6061-T6 Round Bar .750"													
				Location		Loc Qty	<u>Lo</u>	c Code					;
				MAT		80.781				· C - N	S		
				<b>1255</b> :	52	80.781				3 tr. Or	<u>,</u>	01	14.4

DQA:		_ Date:			WORK ORDER NON	~	211501	DAANIGE ( LU					*DART
QA Closed:		Date:			WORK ORDER NON-	-((	JNFOI	RIVIANCE / U		W	ork Order u	odate only	AEROSPACE
					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	er:				9	1	l	c	6		1	Water 104	7
Doub N	do.				Rework		l .	Skid-tube	Crosstube Small Fab		Dro	Water Jet d. Eng. Coor.	Engineering Quality
Part N	NO.				Scrap Use-as-is			Machining	Finishing	-	4	re/Packaging	Other
NCR I	No.				Suspected Unapproved		mem	Large Fab	Composite		1,66,510	Supplier	
Henri	···				Suspected Onapproved	J		Eurge ruo	composite		j	Juppine: [	ا لـــا
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Cause	Date	Step	Qty		or non-conformance	Ch	nief <sub>,</sub> Eng	Descr	ription		Date	Verification	QC Inspector
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Landi	ng Gear				General		_		_		<b>-</b>		
	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced
	Centre N	lot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorre	ct	Temperature/Cure
	Crimp/Ki	ink/Ripple	/Wave		Burrs		Inspect	on Incomplete/Ur	nqualified		Part Lost/Mi	issing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned V	Vrong	
	Heat Tre	at			Cut Too Short		Mislabe	led	[		Power Loss/	Surge	Other
	Inspection	on Strip in	Tube		Drawing		Misread	i	•				
	Marks/C	hatter			Drill Holes		Off-set						
	Turning 9	Sequence			Finish		Out of (	Calibration					
	Wave/Tv	wist in Tub	oe		Fit/Function		Out of 9	Sequence					

DART AEROSPACE LTD	Work Order:	102867
Description: Washer	Part Number:	D3137-5
Inspection Dwg: D3137 Rev: F		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	0PF3	7		F95-04	Venn
Ø0.257	+0.005/-0.000	.257	>		N	i <sub>1</sub>
Ø0.500 x 100°	+/-0.010	,500 × 100°	7		l,	h
Ø0.360	+/-0.010	, 3 <b>66</b>	/		A	١
0.080	+/-0.010	.082	7		Λ	١
0.200	+/-0.010	.201	7		V	1
Ø0.650	+0.000/-0.010	.645	7		.41	h
			1100			
	1					
						erith-titl
			-			

Measured by:	~ A C	Audited by:	and	Prototype Approval:	N/A
Date:	13/06/22	Date:	13/10/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.11.12	New Issue	KJ/JLM	
В	06.03.15	Ø0.650 dimension added; Ø0.660 dimension removed	KJ/JLM , ,	
С	08.12.02	Dwg Rev updated	KJ/DD 🚓	N/

**D3137-041 BRACKET ASSEMBLY D3137-043 BRACKET ASSEMBLY** D3137-045 BRACKET ASSEMB REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.36 WAS 2.48, ZONE A.4 0.480 DIM WAS 0.605, ZONE B.4 5.850 DIM WAS 0.79 ZONE B.5 4.850 DIM WAS 4.975 & ZONE B.5 5.850 DIM WAS 4.975 & ZONE B.5 5.850 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR. AJS 08.05.30 ADD -045 RF 05.11.23 RE-DESIGN D3137-5; CHANGE DIMS DS 04.11.03 ADD -043 DS 03.08.15 ADD RIDGES; ADD MATERIAL PROP DS 03.01.16 NEW ISSUE DS 02.04.17 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. F D3137 MFG. APPR. SHEET 1 OF 5 APPROVED TITLE SCALE BRACKET ASSEMBLY

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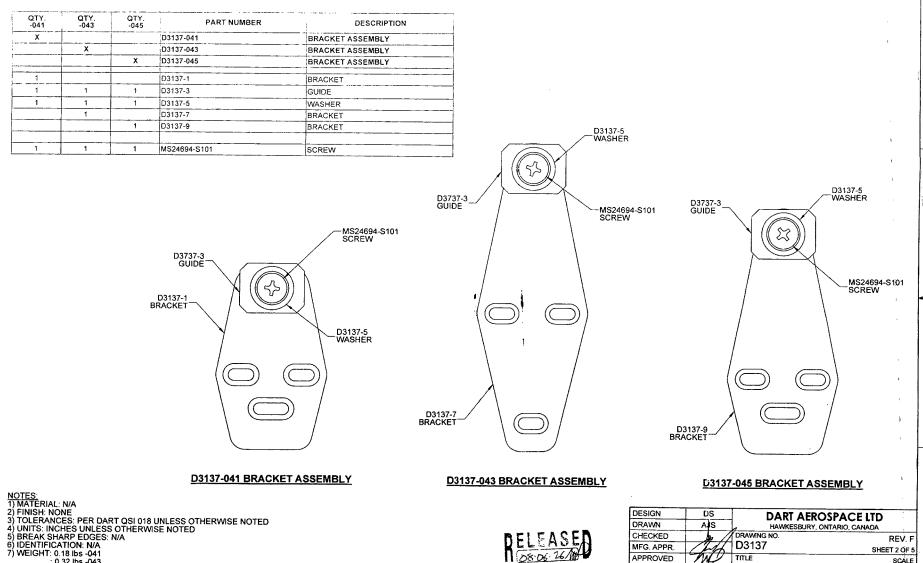
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08.05.30

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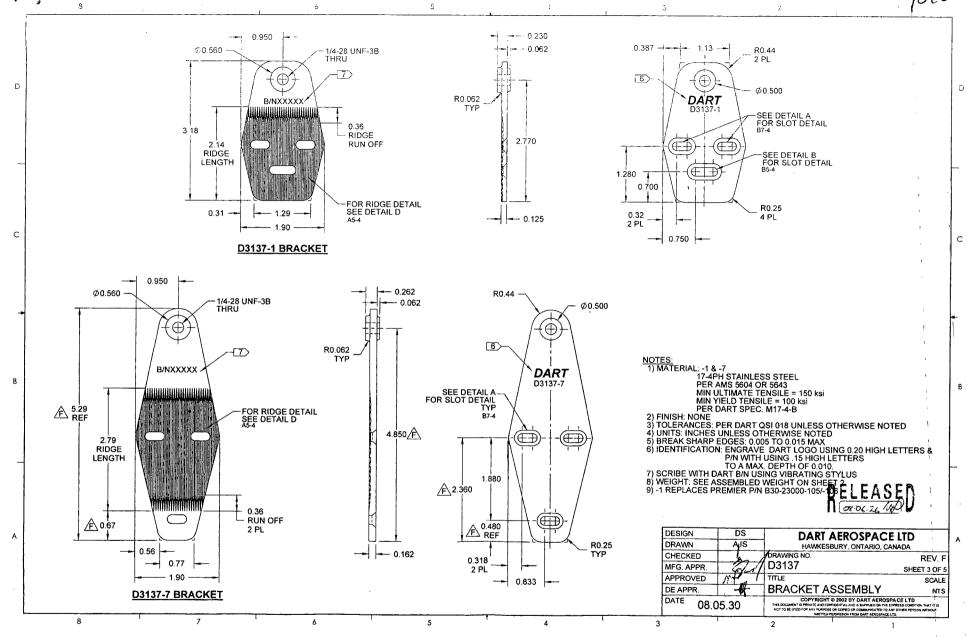


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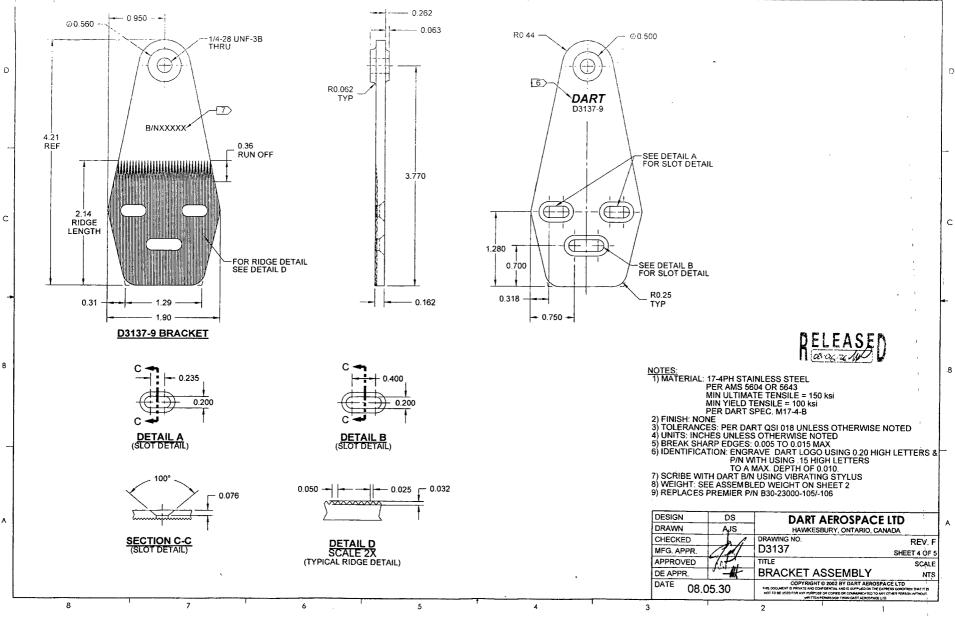
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: 0.32 lbs -043 : 0.27 lbs -045

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CHECKED	De //	DRAWING NO.	REV. F
MFG. APPR.	1h	D3137	SHEET 2 OF 5
APPROVED	TWO	TITLE	SCALE
DE APPR.	<del></del>	BRACKET ASSEMBLY	NTS
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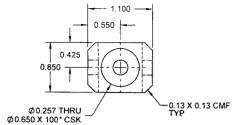


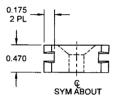
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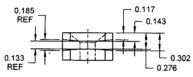
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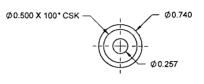
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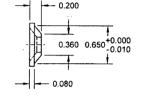








**D3137-5 WASHER** 



**D3137-3 GUIDE** 

NOTES: 1) MATERIAL: -3 DELRIN II 150E OR ACETRON GP ACETAL, BAR (REF DART SPEC M-DELRIN-B) -5 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUI

6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116) OR PER-QQ-A-220/8 (OR AMS 4160) REF. DART SPEC M6061T6R

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY) 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX 6) IDENTIFICATION: NONE 7) WEIGHT SEE ASSEMBLED WEIGHT ON SHEET 2 8) -3 REPLACES PREMIER P/N B30-2300-207 -5 REPLACES PREMIER P/N B30-2300-209

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. F
MFG, APPR.	94	D3137	SHEET 5 OF 5
APPROVED	14	TITLE	SCALE
DE APPR.	-#-	BRACKET ASSEMBLY	NTS
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